



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D4956-21**  
**Job Sheet 173006**



Part No: D4956-21

Job Qty: 8 ea

Part Name: Wearplate Center



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/23/18

Job Tracking No:

Due Date: 3/5/18

Created By: Logan David

Type: Stock

Description:

Note: DWG REV A SHEETS 3,8 IPP REV:A 14.04.22 NEW ISSUE DD VERF:JLM

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off          |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-------------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                   |
| 90    | Start up Operation | 8 Ea  |            | 3/3/18   | 0.00      | 0.00    | Start Up Waterjet     |           | SC 18/03/18       |
| 100   | Waterjet           | 8 pcs |            | 3/3/18   | 0.00      | 1.47    | Waterjet1             |           | SC 18/03/18       |
| 110   | QC                 | 8 pcs |            | 3/3/18   | 0.00      | 0.00    | QC2 Waterjet-1        |           | SC 18/03/18       |
| 120   | QC                 | 8 pcs |            | 3/3/18   | 0.00      | 0.00    | QC8-5                 |           | 38                |
| 130   | Brake NC           | 8 pcs |            | 3/3/18   | 0.00      | 0.39    | Brake NC 1            |           | 38                |
| 140   | QC                 | 8 pcs |            | 3/3/18   | 0.00      | 0.00    | QC5                   |           | 38                |
| 150   | HandFinish         | 8 pcs |            | 3/5/18   | 0.00      | 0.82    | HandFinish4           |           | AD 15 MAR 15 2018 |
| 160   | QC                 | 8 pcs |            | 3/5/18   | 0.00      | 0.00    | QC3                   |           | 11 MAR 15 2018    |
| 170   | Packaging          | 8 pcs |            | 3/5/18   | 0.00      | 0.00    | Packaging3-2          |           | FP002 MAR 19 2018 |
| 180   | QC21-SA            | 8 Ea  |            | 3/5/18   | 0.00      | 0.00    | QC21                  |           | 21 MAR 19 2018    |

Part Op 100 - 1-Cut as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary  
 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB  
 120 - QC8- Inspect parts - second check  
 130 - Form as per dwg FORM JOGGLE AS DWG  
 140 - QC5- Inspect part completeness to step on W/O  
 150 - 1- After finish, coat entire top (concave) surface as per note 2 dwg D4956. TEXTURED COATING  
 B#: 138819  
 160 - QC3- Inspect Part Finish  
 170 - Identify as per dwg & Stock Location: \_\_\_\_\_ LOCATION : FP002  
 180 - QC21- Final Inspection - Work Order Release

### Job BOM

| Part / Item | Component Name     | Quantity           | Operation             | Container |
|-------------|--------------------|--------------------|-----------------------|-----------|
| M304S20GA   | 304/316 .040 Sheet | 6.7200 sf (.84 ea) | 90-Start up Operation |           |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | M304S20GA      | 7        | 169       | 0         |

### Part Specifications

Specifications could not be found.



**Inspector:**

Date: 03/13/18

72

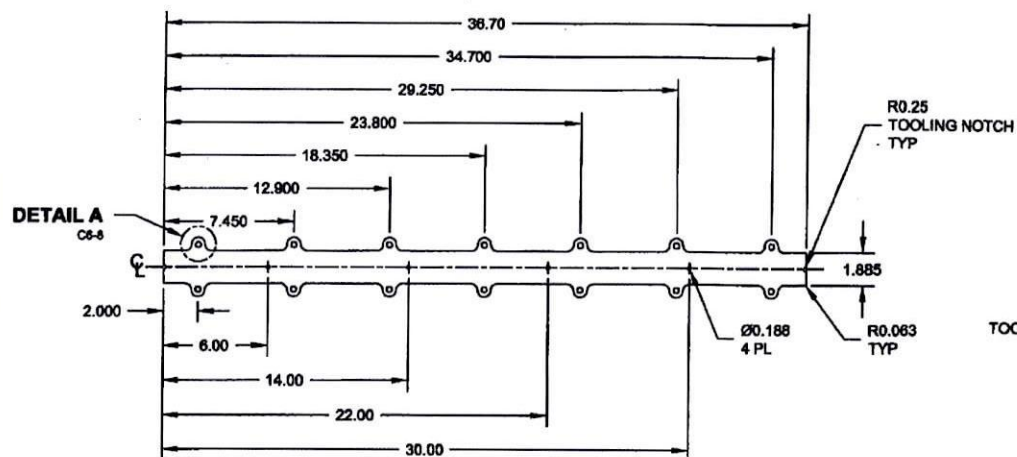
## FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

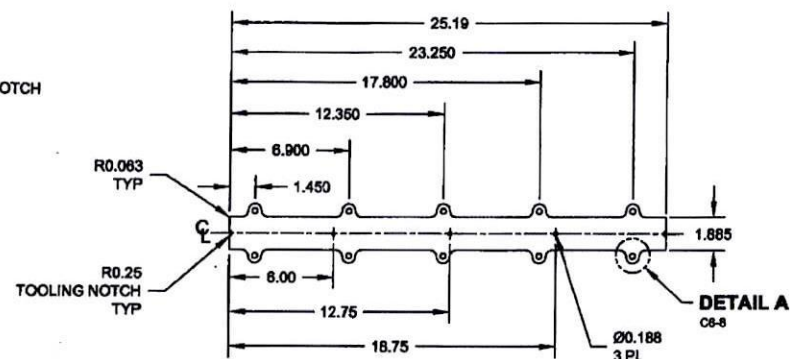
|                 |                        |                       |
|-----------------|------------------------|-----------------------|
| Measured by: SC | Audited by: 38<br>9-88 | Preliminary Approval: |
| Date: 18/03/13  | Date: MAR 13 2018      | Date:                 |

| Rev | Date     | Change    | Revised by | Approved                                                                              |
|-----|----------|-----------|------------|---------------------------------------------------------------------------------------|
| A   | 14.08.27 | New Issue | KJ         |  |





**D4956-21F FLAT PATTERN**



**D4956-25F FLAT PATTERN**



**D4956-21 WEARSHOE**  
(MAKE FROM D4956-21F)



**D4956-25 WEARSHOE**  
(MAKE FROM D4956-25F)

**NOTES**

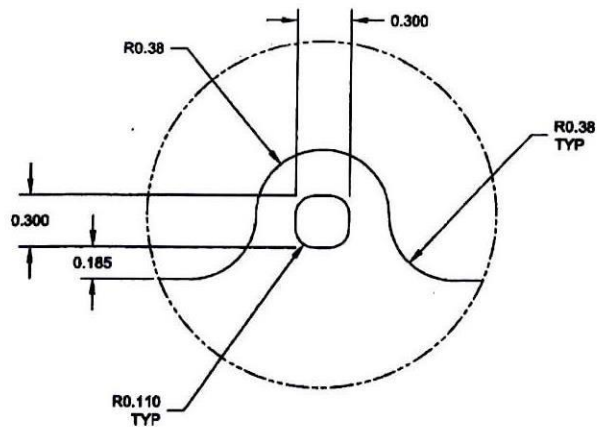
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.038 THICK (20 GAUGE)  
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S20GA
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: D4956-21 = 0.82 lbs; D4956-25 = 0.58 lbs
- 8) SYMMETRY: ABOUT CENTERLINE

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NO. 173006

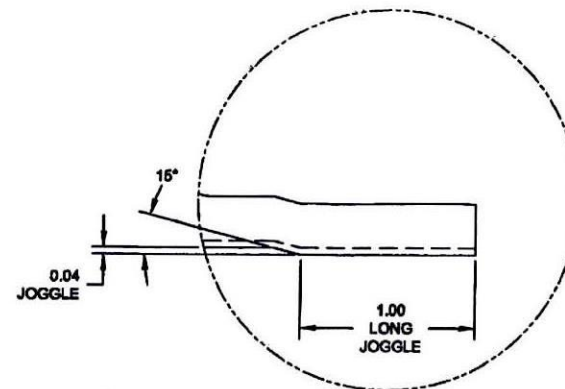
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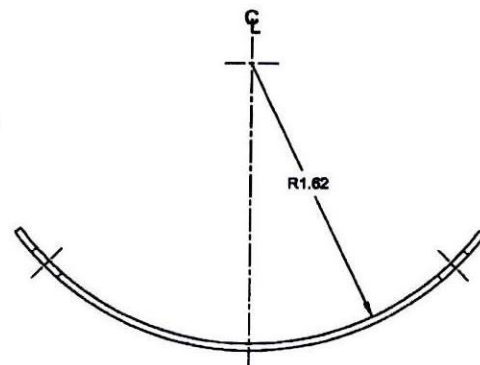
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| DRAWN                                                                                                                                                                                                                          |          | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED                                                                                                                                                                                                                        | AP       | DRAWING NO.                            | REV. A       |
| MFG. APPR.                                                                                                                                                                                                                     | AS       | D4956                                  | SHEET 3 OF 8 |
| APPROVED                                                                                                                                                                                                                       |          | TITLE                                  | SCALE        |
| DE APPR.                                                                                                                                                                                                                       | AS       | WEARSHOE                               | NTS          |
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**DETAIL A** C8-1 C4-1  
C8-2  
C8-3 C1-3  
C2-4  
C8-5 C2-5  
C8-6 C2-6  
C4-7 C3-7



**DETAIL B** B6-1 B2-1  
B3-2  
B5-3 B1-3  
B2-4  
B4-7 B1-7



**SECTION C-C** B7-1 B3-1  
B5-2  
B7-3 B3-3  
B6-4  
B7-5 B3-5  
B7-6 B3-6  
B7-7 B3-7

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| DRAWN                                                                                                                                                                                                             |          | <b>HAWKESBURY, ONTARIO, CANADA</b>     |              |
| CHECKED                                                                                                                                                                                                           | AP       | DRAWING NO.                            | REV. A       |
| MFG. APPR.                                                                                                                                                                                                        |          | D4956                                  | SHEET 8 OF 8 |
| APPROVED                                                                                                                                                                                                          |          | TITLE                                  | SCALE        |
| DE APPR.                                                                                                                                                                                                          |          | WEARSHOE                               | NTS          |
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